

Date: Monday, 6/5/2006 7:40:37 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER KIT
Job Number	: 27340E		
Estimate Number	: 11452		
P.O. Number	:	Part Number	: D314057
This Issue	: 6/5/2006	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3140 REV D1
First Issue	: / /	Project Number	: N/A
Previous Run	: 27323E	Drawing Revision	: D1
	Type	Material	:
	: SMALL /MED FAB	Due Date	: 7/15/2006
Written By	:	Qty:	1
Checked & Approved By	:	Um:	Each
Comment	: Est. B02.11.13 Removed D3140-65/-81/-83; Added D3140-301 K J Est. Rev C New dwg rev. ecn781 06.04.18 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D314009	Doubler Assembly
-----	---------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Doubler Assembly

Pick:

Qty Part Number Description Batch

2.1 D3140-09 Doubler Assy 2x B27341 / ~~1x B31127~~

2.0	D3140101
-----	----------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Doubler

Pick:

Qty Part Number Description Batch

3.2 D3140-101 Doubler B31464

3.0	D3140241	Doubler
-----	----------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Doubler

Pick:

Qty Part Number Description Batch

3.1 D3140-241 Doubler B27373x3

4.0	D3140301	Doubler
-----	----------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Doubler

Pick:

Qty Part Number Description Batch

3 1x B34381 / 2x B26797

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 7:40:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER KIT

Job Number: 27340E

Part Number: D314057

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D3140-301 Doubler

5.0

D314087

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Pick:

Qty Part Number Description Batch

3 ~~1~~ D3140-87 Doubler B 2734543

6.0

D314091

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Pick:

Qty Part Number Description Batch

3 ~~1~~ D3140-91 Doubler 2x B 27378 / 1x B 19974

7.0

D314095

Doubler



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Doubler

Pick:

Qty Part Number Description Batch

3 ~~2~~ D3140-95 Doubler 3x B 27346

8.0

D314097

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Pick:

Qty Part Number Description Batch

3 ~~1~~ D3140-97 Doubler 3x B 27379

9.0

D314099

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Pick:

Qty Part Number Description Batch

3 ~~1~~ D3140-99 Doubler 3x B 31465

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/02/20

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 7:40:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER KIT

Job Number: 27340E

Part Number: D314057

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D3140103

DOUBLER



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 ~~1~~ D3140-103 Doubler 3X B 27371

11.0

D3140105

DOUBLER



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 ~~1~~ D3140-105 Doubler 1XB 27372 / 2XB 34379 C208102125

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

D cel 02/26

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A ship to Delastock

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D cel 02/26

Job Completion



C2 10/24/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3140	REV. D SHEET 1 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
DI	06.03.31	1.75 WAS 1.88; 4.75 WAS 4.13	

RELEASED
05.12.01

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET

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DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3140	REV. 0 SHEET 2 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED
05.12.01

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

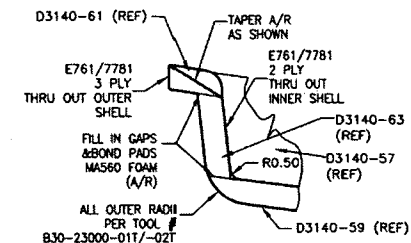
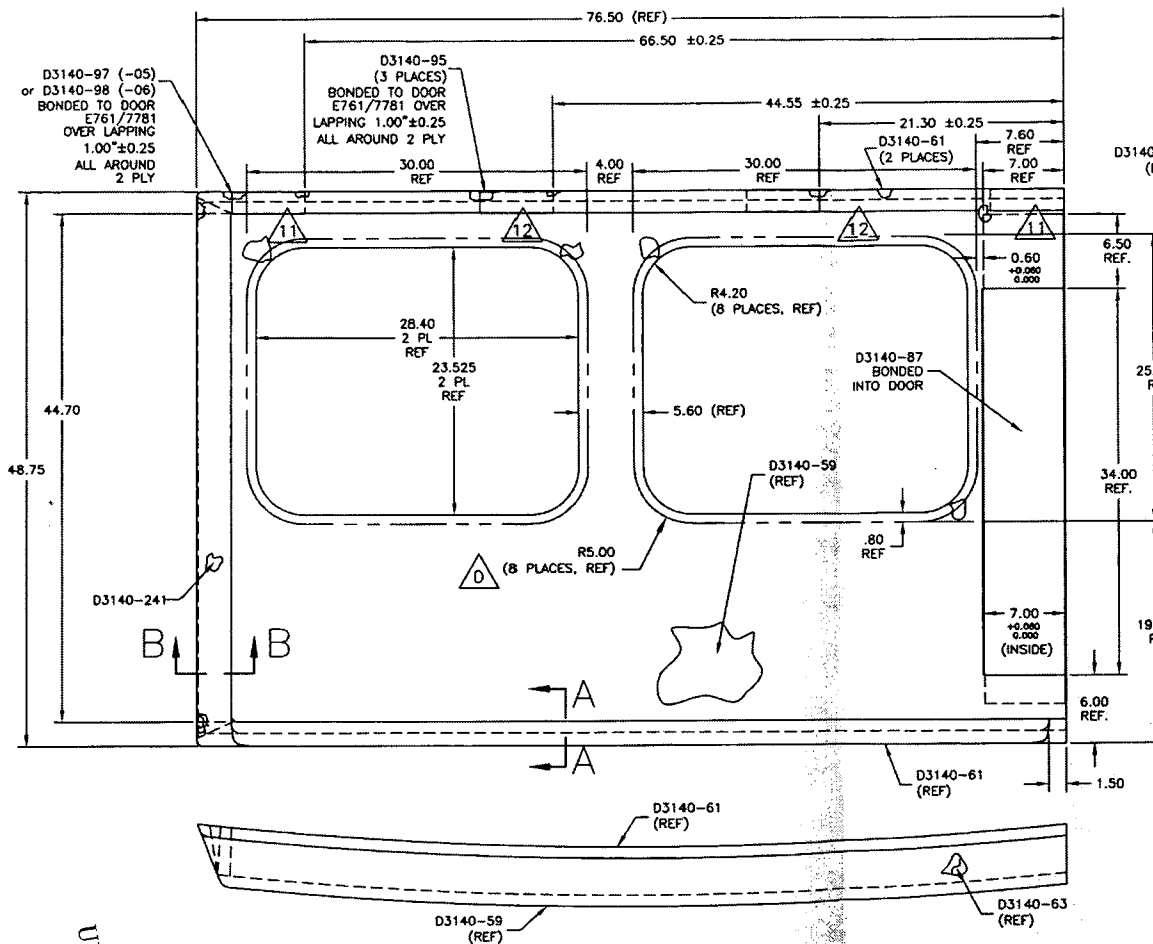
13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

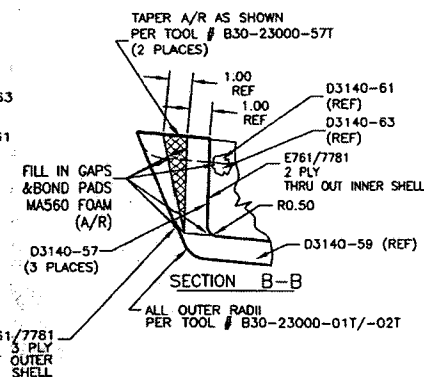
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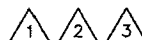
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RELEASED
05.11.23



D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)
(WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

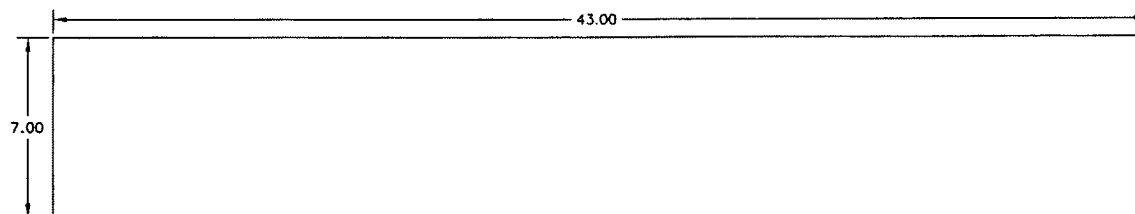


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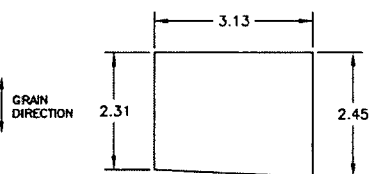
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DATE 05.11.23	TITLE DOOR	SCALE NTS	

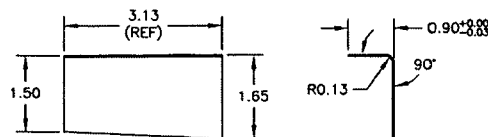
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D3140-87 DOUBLER $\triangle 4$
(REPLACES PREMIER P/N B30-23000-87)



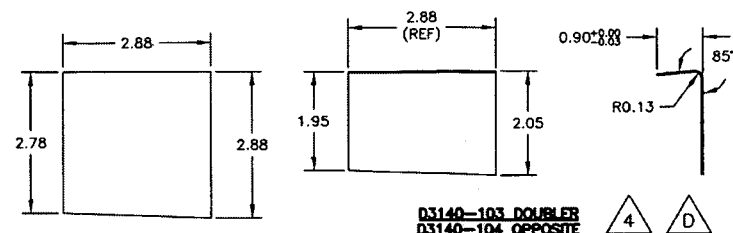
D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)



D3140-105 DOUBLER $\triangle 4$ $\triangle D$
D3140-106 OPPOSITE

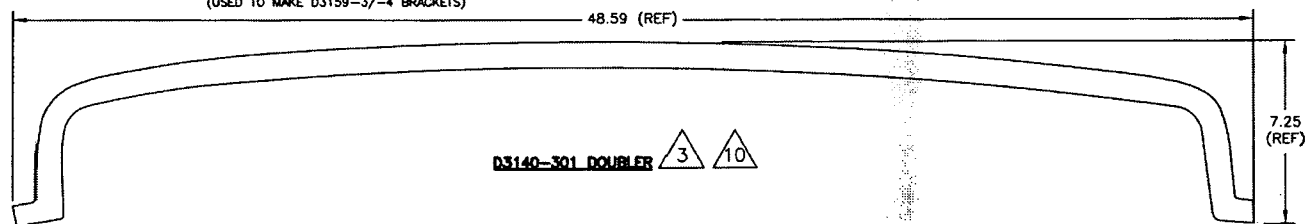


D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)

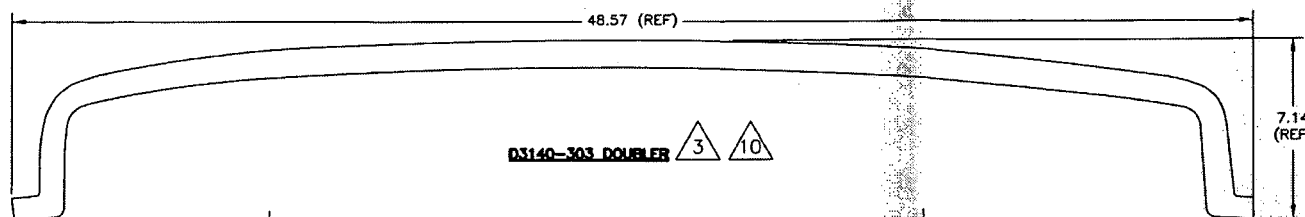


D3140-103 DOUBLER $\triangle 4$ $\triangle D$
D3140-104 OPPOSITE

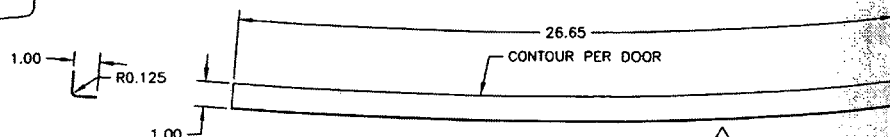
D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/-4 BRACKETS)



D3140-301 DOUBLER $\triangle 3$ $\triangle 10$



D3140-303 DOUBLER $\triangle 3$ $\triangle 10$



D3140-85 ANGLE $\triangle 6$
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

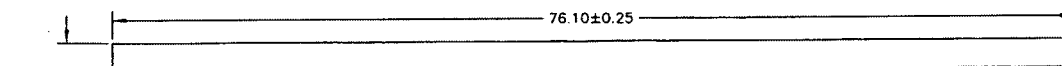
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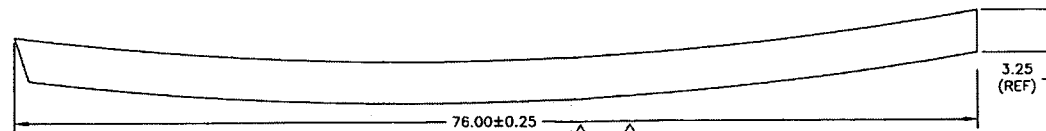
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DATE 05.11.23	TITLE DOOR	SCALE NTS	

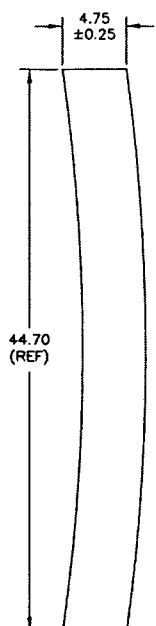
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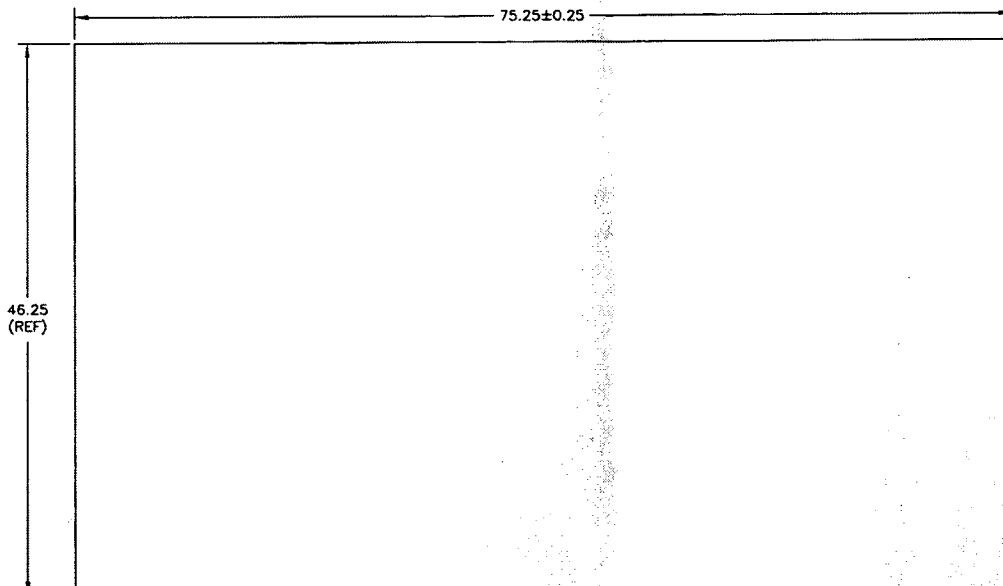
D3140-61 PAD $\triangle 3$ $\triangle 7$
(REPLACES PREMIER P/N B30-23000-61)



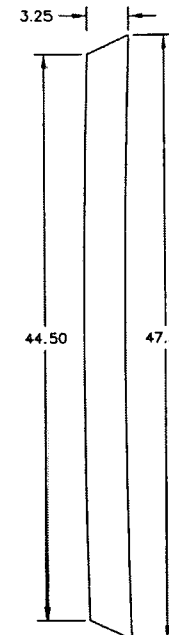
D3140-63 PAD $\triangle 3$ $\triangle 7$
(REPLACES PREMIER P/N B30-23000-63)



D3140-57 PAD
(REPLACES PREMIER P/N B30-23000-57)
 $\triangle 3$ $\triangle 7$



D3140-59 PAD $\triangle 7$
(REPLACES PREMIER P/N B30-23000-59)



D3140-241 DOUBLER $\triangle 5$
(REPLACES PREMIER P/N B30-23000-241)

RELEASED
0511201

R1.00
(2 PLACES, REF)

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		DATE 05.11.23		TITLE DOOR	SCALE	NTS

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Dait Aerospace

①

N° DE COMMANDE - ORDER NO.		DÉP. - DEPT.	DATE 07/11/12
VENDU À - SOLD TO		EXPÉDIÉ À - SHIP TO Dedustek	
ADRESSE - ADDRESS		ADRESSE - ADDRESS	

DATE D'EXPÉDITION - SHIPPING DATE	VIA	CONDITIONS - TERMS	N° D'ENR. DE TAXE - TAX REG. NO.	VENDEUR - SALESPERSON
				attn: David Paradis
4		D3140-95 B 27346	3	
2		D3140-241 1x B 18470 + 1x B 27373	K-015	
2		D3140-301 B 34381		
The rest of the double will be ship next week.				
Thanks, Cheryl				
				TPS/GST
				TVP/PST
214503		SIGNATURE	N° LIC. - LIC. NO.	TOTAL

2

[illegible]

Chantal Lavoie

From: L Lacelle [llacelle@dartaero.com]
Sent: Friday, October 05, 2007 2:10 PM
To: Clavoie
Subject: FW: Door Kit

From: David Paradis [mailto:dparadis@delastek.com]
Sent: October 5, 2007 1:52 PM
To: 'L Lacelle'
Cc: 'Paul Vaugeois'
Subject: RE: Door Kit

Linda,

We received 3 x D3140-95, and we need 15, so we still need 12 doubler. *4+8 ok.*
 We received 0 x D3140-10 and we need 2, so we still need 2 doubler. *-*
 We received 3 x D3140-87 and we need 5, so we still need 2 doubler. *- ok.*
 We received 3 x D3140-99 and we need 5, so we still need 2 doubler. *- ok.*
 We received 3 x D3140-101 and we need 10, so we still need 7 doubler. *-*
 We received 3 x D3140-244 and we need 5, so we still need 2 doubler. *-*
 We received 3 x D3140-301 and we need 5, so we still need 2 doubler. *-*
 We received 3 x D3140-303 and we need 5, so we still need 2 doubler. *-*

We had problem with the door so we still need 2 x D3140-09.

I will confirm if we still need D3140-106

Regards

David

David Paradis
 Directeur Marketing

Tél:(819)533-5788 Ext 226
 Fax:(819)533-3494
 dparadis@delastek.com

Delastek Inc.
 2699, 5e Av, Suite 14
 Grand-Mère (Québec)
 G9T-5K7

De : L Lacelle [mailto:llacelle@dartaero.com]
Envoyé : 5 octobre 2007 11:29
À : 'David Paradis'
Objet : RE: Door Kit

This is what we already sent you... please advise....????
 Linda

10/12/2007

Dait Aerospace

1

N° DE COMMANDE - ORDER NO.		DÉP. - DEPT.		DATE 07/08/31	
VENDU À - SOLD TO		EXPÉDIÉ À - SHIP TO Delestek 2699 ⁵ Avenue Lord 14			
ADRESSE - ADDRESS		ADRESSE - ADDRESS Bland-meir QC G9T-5K7			
DATE D'EXPÉDITION - SHIPPING DATE		VIA		CONDITIONS - TERMS Atten: David Harachie	
				N° D'ENR. DE TAXE - TAX REG. NO. 819-533-5788	
				VENDEUR - SALESPERSON	
	3X	D3140-87	B 27345	✓	
	3X	D3140-91	2x B27378	1x B19974	✓
	2X	D3140-92	2x B27377		
	3X	D3140-97	B 27379	✓	
	3X	D3140-99	B 31465	✓	
	3X	D3140-101	B 31464	✓	
	1X	D3140-105	1x B27372	✓	
	3X	D3140-241	B 27373	✓	
	2X	D3140-301	2x B26797	✓	
	3X	D3140-303	B 27374		
	3X	D3140-09	2x B27341 / 1x B31177	✓	
use for P/O : 1429					
thanks Charrel.					
the rest of the double will be ship next week. sept 08 2007					
				TPS/GST	
				TVP/PST	
214724		SIGNATURE		N° LIC. - LIC. NO.	
				TOTAL	

2

 BlueLine® DCB156

©Blueline®, 2006

3

 BlueLine® DCB156

©BlueLine®, 2006

L Lacelle

From: David Paradis [dparadis@delastek.com]

Sent: October 4, 2007 11:09 AM

To: 'L Lacelle'

Subject: RE: Doubleur

For the next door set.

David

David Paradis
Directeur Marketing

Tél: (819) 533-5788 Ext 226
Fax: (819) 533-3494
dparadis@delastek.com

Delastek Inc.
2699, 5e Av, Suite 14
Grand-Mère (Québec)
G9T-5K7

De : L Lacelle [mailto:llacelle@dartaero.com]

Envoyé : 4 octobre 2007 10:22

À : 'David Paradis'; 'Linda Lacelle (E-mail)'

Cc : 'Paul Vaugeois'; 'Jocelyne Laurin'; 'Mélanie Godin'

Objet : RE: Doubleur

Is this for the doors that are currently in production, or for the next doors to produce?

Please advise asap

Thx

Linda

From: David Paradis [mailto:dparadis@delastek.com]

Sent: October 4, 2007 9:46 AM

To: 'Linda Lacelle (E-mail)'

Cc: 'Paul Vaugeois'; 'Jocelyne Laurin'; 'Mélanie Godin'

Subject: Doubleur

Bonjour Linda,

The left door kit is almost ready to ship and we would like to continue the production before the material due date.

To continue we need these doublers:

1 x D3140-09 ✓

2 x D3140-10 ✓

2 x D3140-87 ✓

~~12 x D3140-95~~ ✓ 4x B27370

2 x D3140-99 ✓

7 x D3140-101 ✓

1 x D3140-106 ✓ B34380

2 x D3140-241 ✓ 1x B18470 / 1x B27373

04/10/2007

2 x D3140-301 ✓ B 34391
2 x D3140-303 ✓

Thank

David

David Paradis
Directeur Marketing

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04/10/2007